DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-022888 Address: 333 Burma Road **Date Inspected:** 18-Apr-2011

City: Oakland, CA 94607

OSM Arrival Time: 1500 **Project Name:** SAS Superstructure **OSM Departure Time:** 300 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China

CWI Name: Sha Zhi **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A N/A **Electrode to specification:** No **Weld Procedures Followed:** Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Chuang Xin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Tower Lift 6 PCMK: WSD1-TL6-4A/D-1, 4

Welder: 041271 WPS-B-P-2112

PCMK: ESD1-TL6-2A/D-1, 4

Welder: 040614 WPS-B-P-2112

Components: Traveler Rail PCMK: 25TR1-002-016



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Welder: 044541 Report: B-WR20599

WPS-345-SMAW-2G (2F)-Repair-1

PCMK: 34TR1-001-009

Welder: 044551 Report: B-WR20598

WPS-345-SMAW-2G (2F)-Repair-1

Trial Assembly Yard

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Yang

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: OBG 13 West Line

PCMK: SA7512-001-024

Welder: 047869 Report: C-WR2927

WPS-345-SMAW-3G (3F)-FCM-Repair-1

Components: OBG 12 West Line

PCMK: SEG3013V-102

Welder: 066674

WPS-B-P-2212-TC-U4b-FCM-1

PCMK: EP3020-001-002, 007, 008

Welder: 067611

WPS-B-P-2112-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Yang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: OBG 12 West Line PCMK: 12CW+13AW X4389B

Welder: 203871 Report: B-WR20667

WPS-345-FCAW-1G (1F)-ESAB-FCM-Repair-1

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 %

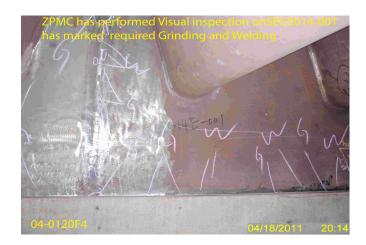
WELDING INSPECTION REPORT

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of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; OBG13 East Line, on item number 5 of NWIT tracker document # 08860,

And OBG12 East Line, on item number 1& 2 of NWIT tracker document # 08863,

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer